

Work Order ID 63905

Thursday, November 18, 2010 3:02:31 PM



Page 1

Item ID: D3927-3

Accept



Setup Start



Revision ID:

Item Name: Guard

Stop



Start Date: 11/19/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/26/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-11-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3927	B								

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut MAT 16.960" Long

SL 10/12/14



110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

HAAS

1-Mill as per folio FA & dwg D,

FOLIO REV: AA

DWG REV: B

2-Deburr as required

SL 10/12/14

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 10/12/14



QC

Memo

0.00

Quality Control

4 0

130

QC8- Inspect parts - second check

0.00

aml 10/12/14



QC

Memo

0.00

Quality Control

4 0

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

C 10/12/14 (4)

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Page 3

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/15
MF
10-12-14

Dart Aerospace Ltd

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Picklist Print

Thursday, November 18, 2010 3:02:31 PM

Page 1

Work Order ID: 63905



Parent Item: D3927-3



Parent Item Name: Guard

Start Date: 11/19/2010

Required Date: 11/26/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
10.10.21 as per revB DD verified by:

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MDELRLNB2.000X02.0
00

Purchased

No

100

f

11.5340

1.68

7.073684



SL 10/21/13

DELRLN BAR

Location

Loc Qty

Loc Code

MAT

11.534

111828

6

115685

1.834

116077

3.7

116266

7.1

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 63905
Description: Guard		Part Number: D3927-3
Inspection Dwg: D3927	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	0.257	✓		Vern. J1-3	
1.52	+/-0.030	1.518	✓		"	
1.04	+/-0.030	1.045	✓		"	
1.10	+/-0.030	1.10	✓		"	
16.71	+/-0.030	16.716	✓		H-G	
34°	+/-0.5°	34°	✓			
1.52	+/-0.030	1.518	✓		"	
1.23	+/-0.030	1.223	✓		"	
0.50	+/-0.030	0.497	✓			
0.950 ?	+0.030 +0.020	0.934	✓		H-G	
1.50	+/-0.030	1.502	✓		"	
0.88	+/-0.030	0.893	✓		"	
0.80	+/-0.030	0.798	✓		"	
0.60	+/-0.030	0.599	✓		"	
0.900	+/-0.010	0.900	✓		"	
0.25 x 45°	+/-0.030 x 0.5°	0.25 x 45°	✓		"	

Measured by: SK
Date: 10/12/14

Audited by: SK
Date: 10/12/14

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	10.11.12	New Issue	KJ	SK

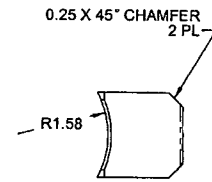
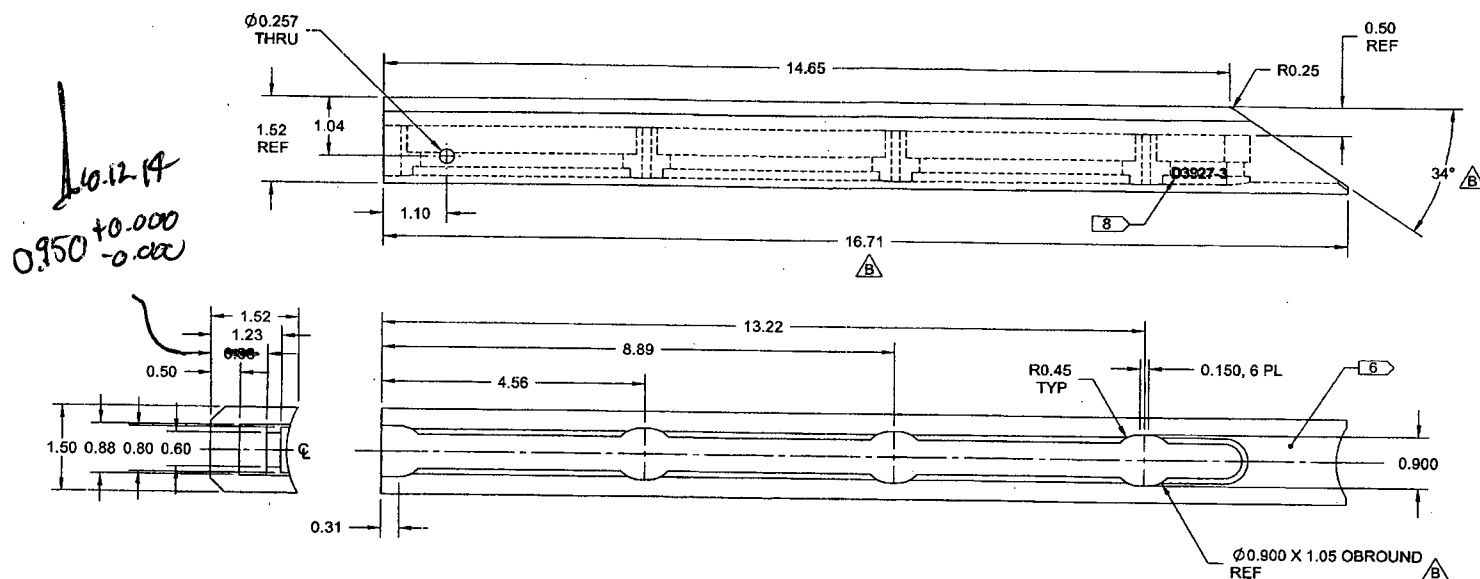
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D3927-3 GUARD

RELEASED
2010-09-15

- NOTES:**
 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.5 THICK
 PER DART SPEC M-DELRIN-S1.5
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH B/N PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
 7) WEIGHT: 0.74 lbs
 8) ENGRAVE "D3927-3" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015 ±0.005 IN LOCATION INDICATED

DESIGN	<i>g</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3927 TITLE GUARD COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PARTIAL AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	REV. B
DRAWN	<i>g</i>		SHEET 2 OF 2
CHECKED	<i>g</i>		SCALE
MFG. APPR.	<i>g</i>		NTS
APPROVED	<i>g</i>		
DE APPR.	<i>g</i>		
DATE	10.08.22		

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